

Hazards

-Heat

-Electrical

Electricity

AC

DC+

DC-

Ground

Rods—Numbering system

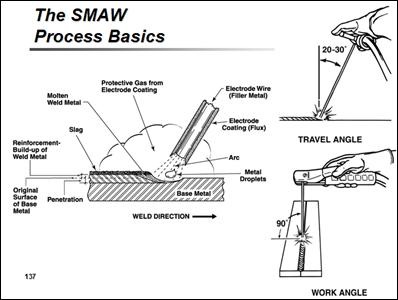
The "60" in 6010 means 60,000 pounds' tensile strength (the ability to resist being pulled apart) per square inch. The "1" means it can be run in any position—flat, horizontal, vertical, or overhead. 6011 runs on AC and DC+

(direct current electrode positive DCEP)

Both are fast-freeze rods, meaning that the weld puddle changes from liquid to solid rapidly. They also have deep penetration; produce a flat, rippled bead; and leave little slag. They are great for all positions, and they are used primarily by pipefitters, pipeliners, and boilermakers. The 6010 and 6011 rods intimidate many first-time welders. Because they require more manipulation, they are a bit harder to run than 7018.

Being a low-hydrogen rod, 7018 requires an environment in which no moisture is allowed to get into the flux. This rod runs completely different from the 6010 and 6011 rods—it is much smoother and easier. More of a "drag" rod. The flux contains almost no hydrogen, and the rod produces smooth, strong welds that are very ductile.

If the flux is broken only off the tip, they can be long-arced and used. But if the flux is broken in other areas, the rod is useless.

Positions

H (horizontal)

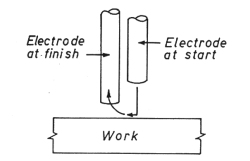
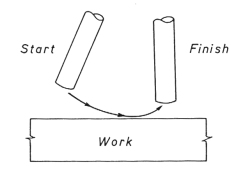
V (vertical)

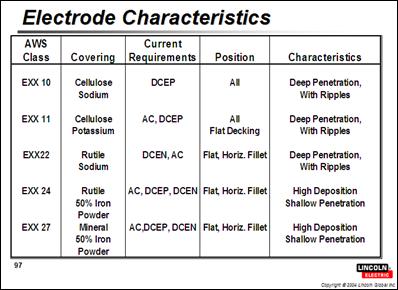
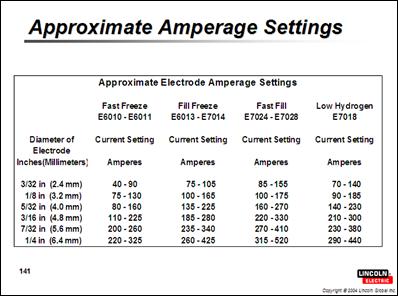
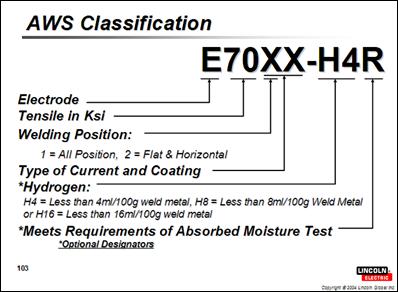
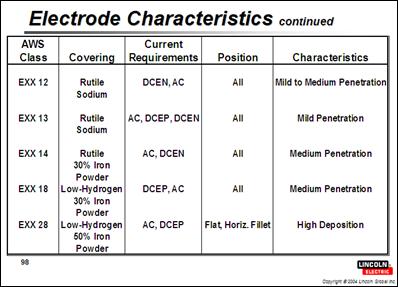
OH (overhead)

Holding the rod/stick

-Stabilize yourself—use elbows and both hands

-Focus on the puddle!

Striking an arc



-Scratching (what you’ll start with)

-Tapping (what you’ll aspire to)

Puddle &running a bead

